SPECIFICATION

TO ALL WHOM IT MAY CONCERN:

BE IT KNOWN THAT I, FRITZ LAUPER of Hauptstrasse 313B, CH-3266 Wiler bei Seedorf, Switzerland, a Swiss citizen, have invented certain new and useful improvements in METHOD AND DEVICE FOR THE MOVEMENT CONTROL OF A TEEMING LADLE WITH A LOW TEEMING HEIGHT IN A TEEMING INSTALLATION of which the following is a specification:

BACKGROUND OF THE INVENTION

The present invention relates to a method for the movement control of a teeming ladle according to the preamble of patent claim 1 and to a teeming machine for carrying out the method, according to the preamble of patent claim 4.

Existing automatic foundry installations for the repeated controlled filling of liquid metals from a tiltable ladle into moulds supplied after one another function in the following manner: the molten mass during the teeming runs via a spout stone with a radius R out of the ladle, wherein the tilting axis of the ladle runs at least approximately through the centre of this radius, the so-called theoretical point of rotation of the spout in a manner such that independently of the tilting angle of the ladle approximately equal geometric and thus flow design relationships are to be achieved. The tilting is effected via a controlled drive which via mechanical connection members engages the ladle.

With such installations one achieves an excellent running of the teeming procedure when teeming on, during the teeming and with the completion of this. However such installations have the disadvantage for teeming with a relatively low teeming height the teeming funnel must lie in the region of the edge of the

mould box. With teeming funnels lying further inside and whilst maintaining the required defined safety distance of the ladle body with respect to the mould box, caused by the segment shape of the teeming ladle, the teeming height increases.

Since teeming funnels lying far inside the mould box may be insufficiently reached, the funnel must be pulled to the edge which with existing models leads to expensive changes. With moulding boxes with weighting iron, often the weighting iron must be modified which again leads to additional cost. However since on the models or weighting irons, changes may not always be carried out, on account of the high teeming height one may only teem with an extended teeming spout. Such a teeming spout is however not suitable for the automatic teeming and with manual teeming can be handled only with difficulty.

From EP Patent 592 365 there is known a teeming method in which the teeming ladle, after the first teeming procedure whilst maintaining a certain safety distanmce of the teeming ladle with respect to the teeming box, with the help of a stationary tilting axis may be displaced further towards the middle of the teeming mould. With this method the stationary tilting axis with the lift drive is attached at the front on the teeming spout and since the tilting bearing required on the tilting axis must likewise be located at a safety distance over the teeming box or the weighting iron, this leads by way of design likewise to a large teeming height. A large teeming height however causes considerable disadvantages; since more kinetic energy must be destroyed a deeper teeming funnel becomes necessary so that the top box may not be optimally exploited. Furthermore more circulation material is required, there is more splatter iron, a more erratic teeming with more turbulence in the funnel, and more sand rinsings amd more sand and gas enclosures are to be expected. With mould boxes with weighting iron the teeming height is increased further since the tilting bearing must lie above the weighting iron.

BRIEF SUMMARY OF THE INVENTION

It is thus the object of the invention to avoid all mentioned disadvantages and to provided a method and a teeming machine for the movement control of a teeming ladle, with which one may always teem with a lower teeming height even when the teeming funnels are arranged at any location in the mould box, and with which the theoretical point of rotation of the spout is stably guided into the lowest possible position. This object is now achieved by the method and the teeming machine which comprises the characterising features of patent claim 1 and 4. Advantageous embodiment forms of the subject-matter of the invention are specified in the dependent patent claims 2, 3 and 5.

BRIEF DESCRIPTION OF THE DRAWINGS

Hereinafter one embodiment example of the invention is described in more detail by way of the schematic drawings. There is shown:

Fig. 1 a lateral view of the teeming machine
Fig. 2 a plan view of the teeming machine shown in Fig. 1,
Fig. 3 a view of the teeming ladle in the teeming position and
Fig. 4 a scetched detail of the teeming ladle suspension.

DETAILED DESCRIPTION OF THE INVENTION

According to Fig. 1 the teeming machine 1 on wheels 2 of a longitudinal vehicle 3 is traversable on rails 4 parallel to a teeming mould path indicated at 5, horizontally in the Y-direction. The longitudinal vehicle 3 carries a transverse vehicle 6, which by way of rail guides 7 is displaceable transversely to this by way of a friction motor 8 in the X-direction. On the transverse vehicle 6 there is mounted a tower-like construction of the teeming machine and its control cabin

10 with the electronic control means 11, with an intermediate arrangement of pressure fluid gauge chambers 12. In the construction 9 a retaining means 13 for the teeming ladle 14 in the vertical direction Z is liftably and lowerably arranged. The retaining means 13 is suspended on a chain 15 which is displaced via chain wheels 17 driven by a lift motor 16. In the retaining means 13 there is mounted a tilt shaft 18 which is rotatable about an axis A and which is driven by a tilt motor 19. The tilt shaft 18 pivots a protruding suspension plate 20 in which the teeming ladle 14 is suspendably fastened.

On operation of the teeming machine the longitudinal vehicle 3 with the teeming ladle 14 filled with moulten metal mass is traversed so far in the Y-direction until the teeming spout 21 at the height of the teeming funnel 22 is opposite the teeming mould 24 loaded with the weighting iron and which is to be cast, which is effected by the electronic control means 11. The electronic control means 11 is provisionally programmed corresponding to the dimensions of the teeming moulds to be cast. According to the programm which is to be called up the friction motor 8, the lift motor 16 and the tilt motor 19 are controlled in a manner such that the theoretical point of rotation of the
spout D with the radius R of the spout stone 25 moves on the curve K1 from above to below which always corresponds to the lowest possible teeming height whilst observing a safety distance. For this the engagement point K of the tilting moment transmitted by the tilt shaft 18 via the suspension plate 20 onto the teeming ladle 14 must move on the curve K2 correspondingly from bottom to top, which is effected by the suitable control of the mentioned motors.

By way of the pressure fluid gauge chambers 12 functioning as weighing cells the teeming procedure may be automatically stopped by the control means 11 in dependence on the cast molten mass weight and may be reassumed with the subsequent teeming mould. With this the electronic control means is programmed such that the lifting and lowering of the teeming spout is carried out in the fast mode during the teeming pause which is to be kept as small as

possible. Until the curves K1 and K2 are passed through and the teeming ladle is thus emptied, in general several teeming moulds may be filled. With the empty teeming ladle the teeming machine must traverse to a loading and unloading station where the empty teeming ladle is replaced by one which is full. Thereupon after traversing back the teeming procedure may be reassumed. In order to avoid such a temporal interruption in teeming, two teeming machines may be arranged next to one another so that with an empty teeming ladle of the first teeming machine the second immediately continues the teeming procedure whilst the first replaces the empty teeming ladle with one which is full. The only condition to this method is that the loading and unloading station can be reached in both directions of the rails 4.

With the protruding suspension plate 20 it is possible for the first time to fasten the teeming ladle only on one of its lateral surfaces and to tilt it. This is achieved with protruding coupling parts 26 and 27 above on the teeming ladle, wherein the part 26 with a part circular recess engages into an axle journal 29 and the part 27 into an opening 30 of the retaining plate 20 by which means the teeming ladle is suspended on the retaining plate. For the lateral stabilisation the teeming ladle 14, with a rounded projection 31, below rests on a protruding part 32 of the suspension plate 20. With this suspension of the teeming ladle there results numerous advantages, thus the teeming machine may be designed smaller, the accessibility between the teeming ladle and teeming mould is improved, only a vertical drive in the Z-direction and a tilting drive about the axis A is necessary, a rotational drive for exchanging the ladle is made possible, by which means this exchange is greatly accelerated and ladles of varying size may be applied.

The spout 21 of the teeming ladle 14 is equipped with an exchangeable spout stone 25. In this manner the stone may be kept smaller and more economical, with the ladle exchange it may be simply and quickly exchanged and fireprooof material is saved. The exact application of the spout stone is

effected by a mounting attached in the snout so that the radius of the spout stone on teeming moves exactly about the theoretical point of rotation of the spout D, by which means teeming flow fluctuations during the complete tilting procedure are avoided.

For holding back the slag, for breaking the waves and for destroying the kinetic energy arising in the ladle by way of the tilting in the vicinity of the spout 21 there is applied a specially formed slag brick 33.

With the described teeming machine practically each and every teeming object may be teemed independently of the accompanying mould box height, since with a model change the electronical control means must be correspondingly newly programmed so that the curves K1 and K2 are matched to the new model.